

Work Order ID 57513

April 8, 2010 7:18:27 AM



Page 1

Item ID: D3275-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crossbolt Spacer

Start Date: 4/08/10 Start Qty: 80.00



Cust Item ID:

Required Date: 4/13/10 Req'd Qty: 80.00

Customer:

Reference:

10.04.08.

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3275

Rev A1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA469 and Dwg D3275

SL 10/05/03

(80)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/05/03

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S.F 10/05/03

80

/

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57513

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Item Name: Crossbolt Spacer

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: LG

0.00



Packaging

Memo

0.00

Packaging

80 0 RE 10/05/17

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/18 J
ME
10-5-18

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 57513



Parent Item: D3275-1



Parent Item Name: Crossbolt Spacer

Start Date: 4/08/10

Required Date: 4/13/10

Comments: IPP Rev:A 04.10.19 New issue KJ/JLM

Start Qty: 80.00

Required Qty: 80.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased	No			100	f	0.0000	22.4505			



ALUM TUBE .3125 x .058w



M114559 23.00 JL 10/05/03

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Remember....

- Lean is war to WASTE.
- Waste is an activity or output that ***adds cost but does not add value***
- You have to get into a mindset of identifying and eliminating all wastes.

The 7 deadly wastes

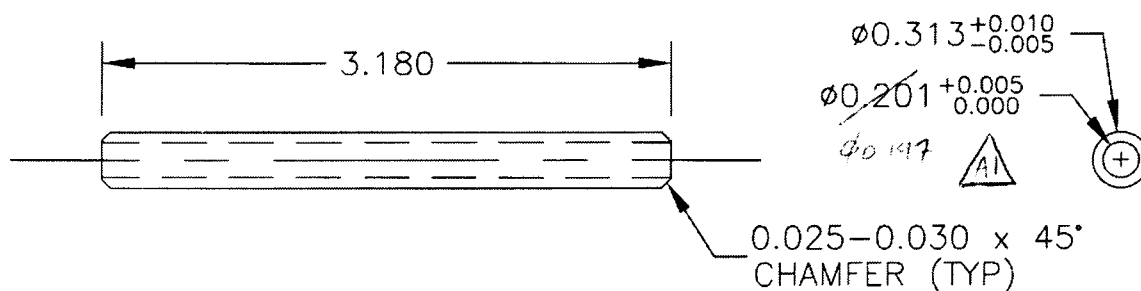
- | | |
|--------------------------|------------------------------------|
| 1. Overproduction | 2. Rework |
| 3. Transportation | 4. Inappropriate / over Processing |
| 5. Unnecessary Inventory | 6. Delays / Waiting |
| 7. Unnecessary Motions | |



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3275	REV. A SHEET 1 OF 1
DATE 04.03.10		TITLE CROSS BOLT SPACER	SCALE 1:1
A	04.03.10	NEW ISSUE	
AI	04.03.10	CHANGE DATE SPEC	

RELEASED
04.06.22

w/o 57513



D3275-1 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6R) M6061T6T3 R13 W.055 AI
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Lean Training Event